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D2432
Job Sheet 210319



Part No: D2432

Job Qty: 12 pcs

Part Name: Bearpaw 19" X 24"



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/4/20

Job Tracking No:

Due Date: 7/2/20

DAS
21
9-88

Created By: Marie Lajeunesse

Type: ~~SOLD~~ Stock

Description:

Note: DWG REV H IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Waterjet - Omax - 1	12 pcs	7/1/20	7/1/20	0.17	3.09	Waterjet - Omax		20/06/18
130	HAAS 4 Axis - B4B	12 pcs	7/2/20	7/2/20	1.00	15.02	HAAS - 1 - B4B		20/06/18
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
140	QC 2	12 pcs	7/2/20	7/2/20	0.00	0.00	QC 2 - 1		20/06/18
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

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				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
150	QC 8	12 pcs	7/2/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
160	Packaging 3-1 - Stock - B4B	12 pcs	7/2/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B ✓
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B

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				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
170	QC 21 - SA	12 pcs	7/2/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 9
Part Op 120 - Waterjet 2 OMAX (Waterjet 2) Cut Blank as per D2432 File Descriptions: 130 - (HAAS CNC vertical machine #1) 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr 140 - (QC2- Inspect parts off machine FAI/FAIB) 150 - (QC8- Inspect parts - second check) 160 - (Identify as per dwg & Stock Location: _____) 170 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	44.4000 sf (3.7 ea)	120-Waterjet - Omax - 1	5235828 5262128	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
120-Waterjet - Omax - 1	MUHMWB10	44	704	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order: 210319
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432	Rev: H	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.055 x 45°	/		Caliper	DCH-05
B	0.200	+/-0.030	.195			Deep gage	REF
C	0.25 x 45°	+/-0.030	.27 x 45°			Caliper	DCH-05
D	R0.250	+/-0.030	1/4			Rad gage	REF
E	0.250	+/-0.010	.255			Micrometer	65011351
F	0.625	+/-0.030	.640			Caliper	DCH-05
G	0.375	+0.030/-0.010	.39			"	"
H	0.950	+/-0.030	.95			"	"
I	19.000	+/-0.030	19			Tape	REF
J	Ø0.260	+0.005/-0.000	.260			Caliper	DCH-05
K	Ø0.93	+/-0.030	.929			Caliper	DCH-05
L	0.30	+0.030/-0.000	.308			Deep gage	REF
M	23.750	+/-0.030	23 3/4			Tape	REF
N	2.000	+/-0.030	2.004			Caliper	DCH-05
O	0.38	+/-0.030	.379			Caliper	DCH-05
P							
Q							
R							
S							
T							
U							
V							

Measured by: Del P	Audited by: ML	Preliminary Approval:
Date: 20/06/22	Date: 20/06/30	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	
E	15.02.09	Dimensions revised	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S283482



Part: D2432

Job No: 210319

Serial No/Batch: S283482

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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